

Work Order ID 73191

Friday, August 26, 2011 7:15:46 AM



Page 1

Item ID: D4417-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/08/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4417

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

2 BR 11-10-25

120

0.00



HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE AS PER DWG

2 BR 11-10-25

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/25QC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4417-011

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Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/10/2011

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
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Picklist Print

Friday, August 26, 2011 7:15:43 AM

Page 1

Work Order ID: 73191

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)





Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP
REV:B 11.08.17 PER REV.B. DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4417-041  Step Assembly		Manufactured	No	73192.		120	Each	0.0000	1	2		BR 11-10-25.	
D4418-1  Step Lug		Manufactured	No	73193		120	Each	0.0000	2	4		BR 11-10-25.	
D2570  Bushing		Manufactured	No			120	Each	44.0000	4	8		BR 11-10-25.	
<div> <div>Location</div> <div>ST017 72960.</div> <div>66933</div> <div>67759</div> <div>73122</div> <div>73753</div> </div> <div> <div>Loc Qty</div> <div>44</div> <div>1</div> <div>6</div> <div>37</div> </div> <div> <div>Loc Code</div> <div>5</div> <div></div> <div></div> <div>3</div> </div>													
D2690-6  Lanyard Assembly		Manufactured	No			120	Each	16.0000	2	4			
<div> <div>Location</div> <div>ST020 73321</div> <div>70920</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> <div>4</div> </div>													
AN4C16A  BOLT		Purchased	No			120	Each	54.0000	2	4			

Location Loc Qty Loc Code
ST358 117441. 54
54

M 116438.
M 118140.

4x=3.25
2x. qty 4

BR 11-10-25.
BR 11-10-25.

Replace
* CBL 1240
CBL 460
11.10.25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:15:43 AM

Work Order ID: 73191

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C36A Purchased No

120

Each

48.0000

2

4



Bolt



BR 11-10-25.

Location

Loc Qty

Loc Code

ST360

48

118518 ✓

48

7.

MS17984-C415 Purchased No

120

Each

6.0000

2

4



Pin, Quick Release



BR 11-10-25.

Location

Loc Qty

Loc Code

ST315

6

118352 ✓

6

4

MS21043-4 Purchased No

120

Each

878.0000

4

8



Nut



BR 11-10-25.

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

838

117793 ✓

482

118378

356

8

D4428-1 Manufactured No

120

Each

2.0000

2

4



Bushing



BR 11-10-25.

Location

Loc Qty

Loc Code

ST

2

73195.

2

72555

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, August 26, 2011 7:15:43 AM

Page 3

Work Order ID: 73191



Parent Item: D4417-011



Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

120

Each

4,558.000

8

16



Washer

OK 11-10-25.

Location

Loc Qty

Loc Code

ST297

4558

117291 ✓

4558

16.

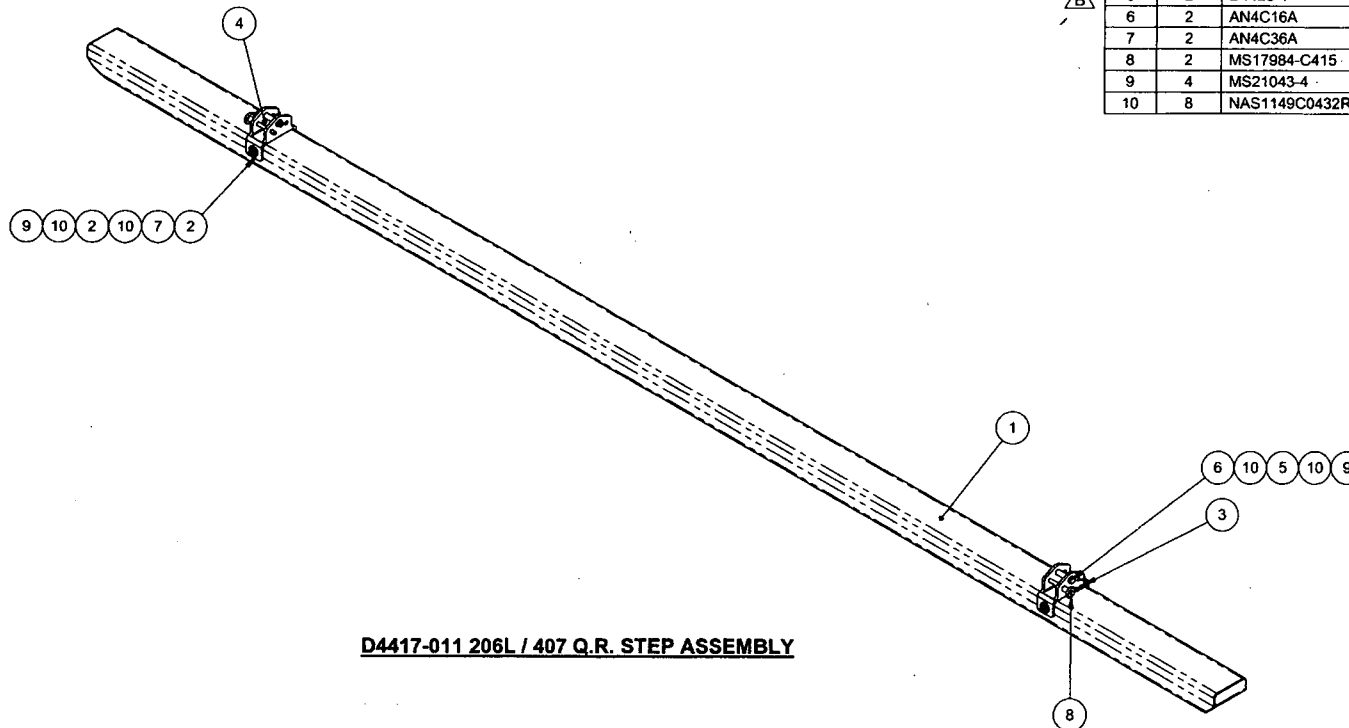
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D4417-011 206L / 407 Q.R. STEP ASSEMBLY

ITEM	QTY -011	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73191
CZ11/08/26

RELEASED
2011-08-02
MP

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -5.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4417 SHEET 1 OF 4 TITLE 206L / 407 Q.R. STEP ASSEMBLY SCALE NTS <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

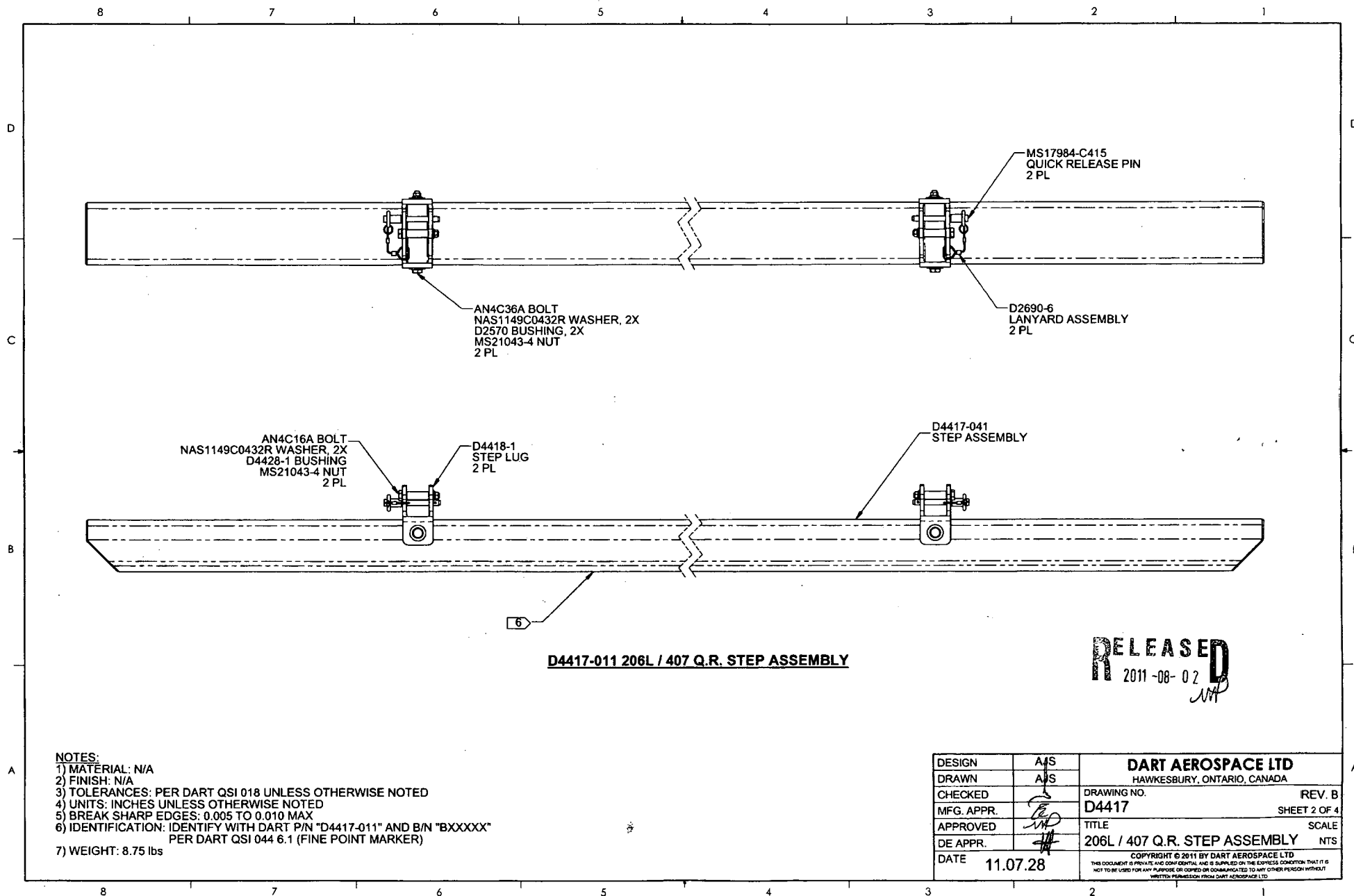
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



RELEASED
2011-08-02
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4417-011" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 8.75 lbs

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MP</i>	D4417	SHEET 2 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

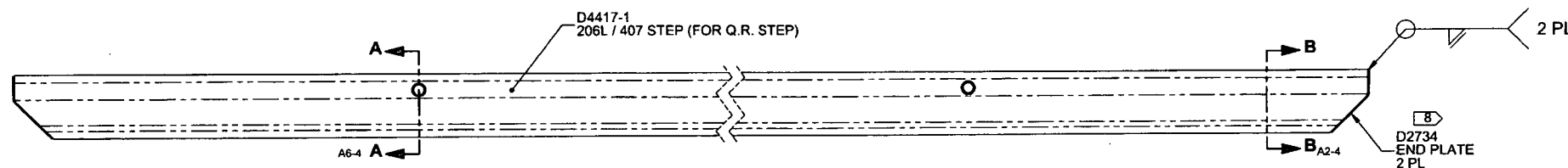
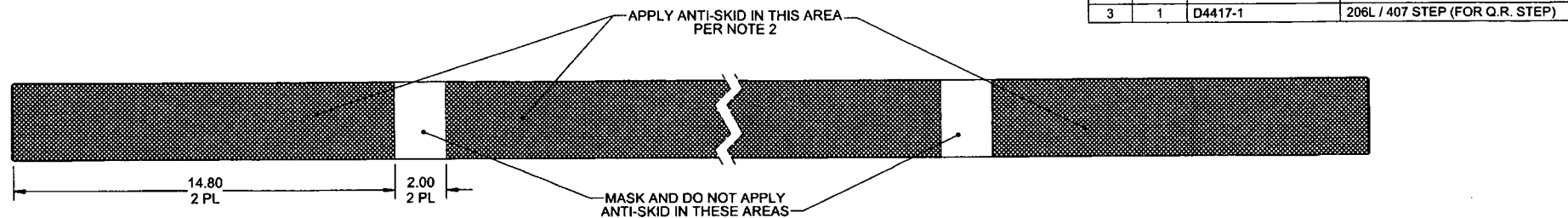
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

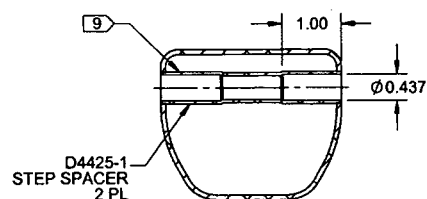
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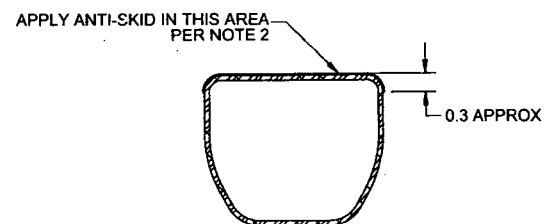
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



D4417-041 STEP ASSEMBLY



SECTION A-A C7-4
SCALE 2X



SECTION B-B C2-4
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002

DESIGN	A.S	DART AEROSPACE LTD	
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4417	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L / 407 Q.R. STEP ASSEMBLY	NTS
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2011-08-02
MP

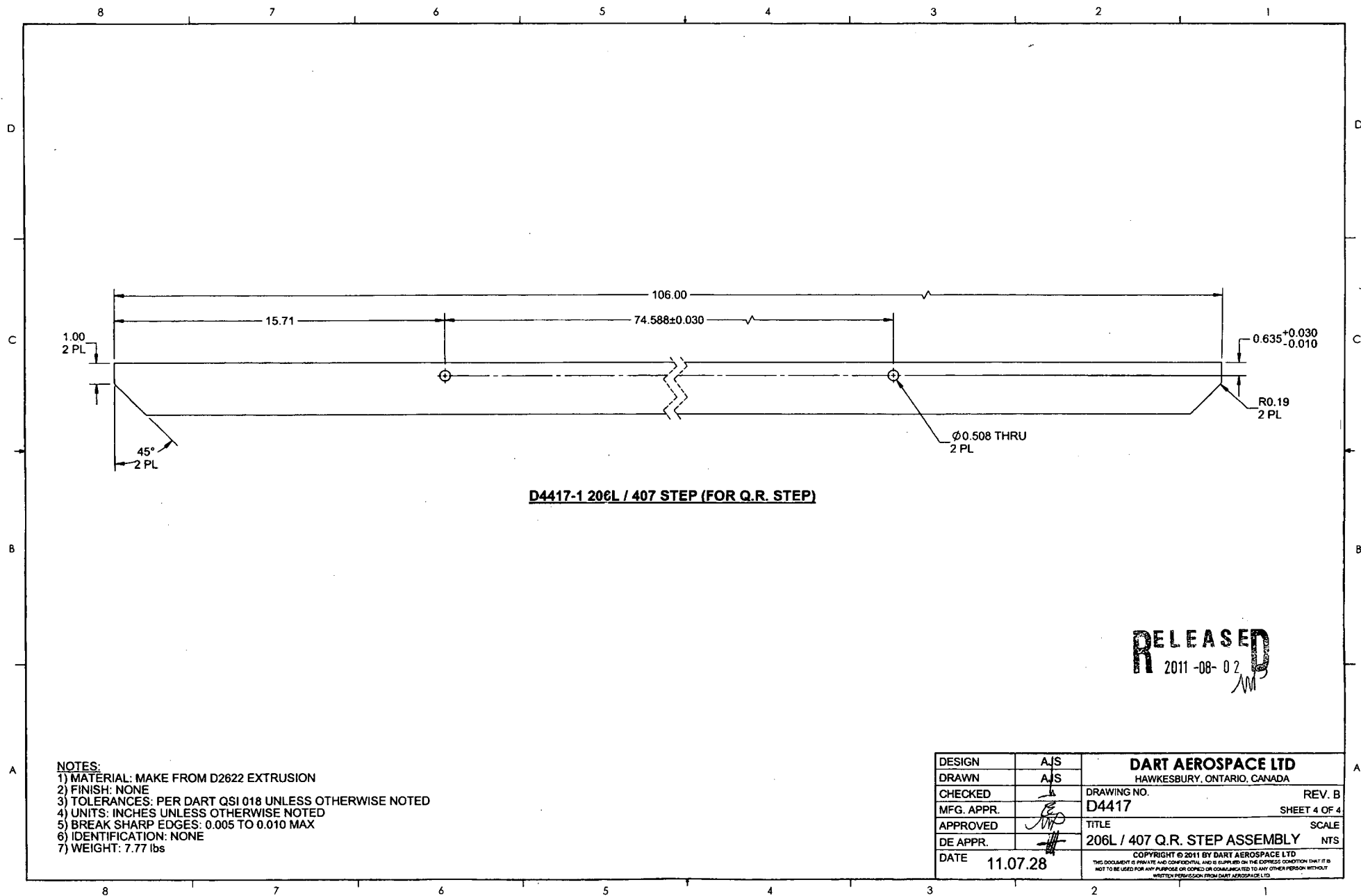
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2011-08-02

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
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